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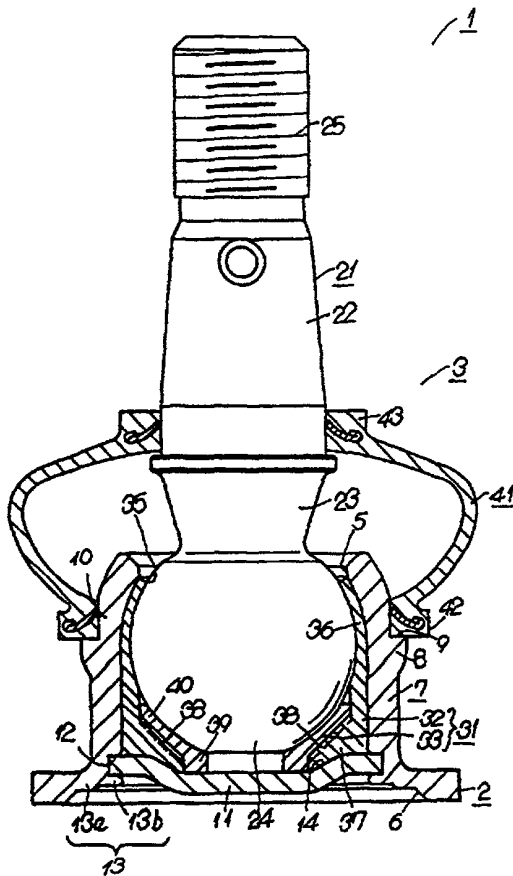
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[続葉有]

(54) Title: UNIVERSAL JOINT DEVICE AND METHOD OF MANUFACTURING THE DEVICE

(54) 発明の名称: 自在継手装置およびその製造方法



(57) Abstract: A universal joint device, wherein a generally cylindrical socket part (7) having a converged opening part (5) at the tip thereof and a mounting opening part (6) at the base end thereof is formed projectedly by pressing a steel plate arm base material in thickness direction, the socket part (7) is fixedly put on a support table (60) of a crimping machine (50) and a spherical head part (24) is stored in the socket part (7) through a bearing seat (31) to install a ball stud (21), a closing plate (11) is closely inserted into the mounting opening (6), a roller (58) is rolled on the inner peripheral edge of the socket part (7), and a first height difference part (13a) projected inward in a flange shape is formed crimping, and the roller (59) is rolled at the tip portion of the first height difference part (13a), a second height difference part (13b) projected inward in flange shape is formed crimping, and a crimped part (13) thinner at the tip side is formed at the height difference, whereby the amount of locking between the closing plate (11) and a crimped part (13) is increased, and the closing plate (11) can be installed surely and stably so as to increase a sealability.

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